

Date: Thursday, 05/03/2009 10:32:00 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 350 BASKET LID (SHORT)
<b>Job Number</b> : 46309B	
<b>Estimate Number</b> : 10210	
<b>P.O. Number</b> :	<b>Part Number</b> : D3266041
<b>This Issue</b> : 05/03/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3266 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 44259B	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 13/03/2009 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUDOR.03.05</u>	
<b>Comment</b> : Est Rev:B Re-Format 05-11-03 JLM Est Rev:C 08-09-10 revB as per dwg (ecn 08-524) DD verified by:EC	

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D31663

Basket Hoop

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty 1 D3166-3 Basket Hoop Batch: B46305SAD 09-03-19 ①

2.0

M304TS0750W065

304 SQ Tube .75x.75x.065W

**Comment:** Qty.: 28.3500 f(s)/Unit Total : 28.3500 f(s)  
 3/4" x 3/4" square tubing 304/316 SS tube .065" wallBatch: M110011

(M304TS0.750W.065)

PD SAD 09-03-19 ①

3.0

D22321

Basket Hinge

**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2232-1

Hinge plate

B39454PD 09-03-19

4.0

D23271

Spacer Bushing

**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2327-1

Bushing

B40390PD 09-03-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: 350 BASKET LID (SHORT)

Job Number: 46309B

Part Number: D3266041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2506

Label Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2506

Label Plate

B44275

PD 09-03-20

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Bracket

B45684

PD 09-03-18

7.0

M304EX07516F

Expanded Metal Flat SS



Comment: Qty.: 10.0000 sf(s)/Unit Total: 10.0000 sf(s)

Pick:

Qty Part Number

Description

Batch

10sf M304EX0.75-16F

Expanded Metal

M110992

SAD 09-03-18 ①

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236 From D3166-3

SAD 09-03-18 ①

2-Cut 3/4" x 3/4" square tubing as per Dwg D3266

SAD 09-03-18 ②

3-Drill holes in D3266-1 as per Dwg D3266 using Drill Jig DT8305

4-Deburr & Remove all markings from material

SAD 09-03-18 ③

5-Weld as per Dwg D3266 using Welding Table and corner Jig Deburr as required

PD 09-03-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Job Number: 46309B

Part Number: D3266041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

09-03-23

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

09/03/23

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

m110939 Pressure Wash MD/

09/03/24

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT:

START TIME:

11:45

OVEN TEMPERATURE:

400°

FINISH TIME:

12:15

2ND COAT:

START TIME:

\_\_\_\_\_

OVEN TEMPERATURE:

\_\_\_\_\_

FINISH TIME:

\_\_\_\_\_

MD/FZ

09/03/24

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk Batch: m1109917

and Spray Paint black Batch: m110907

as per Dwg D3266 and QSI 005 4.4

09-03-25

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

09-03-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Job Number: 46309B

Part Number: D3266041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



①  
D09103127  
MK  
09-03-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

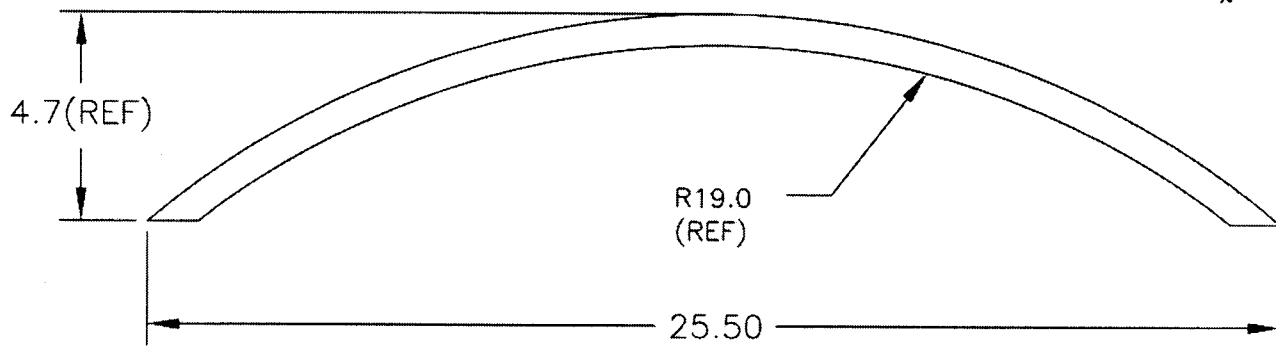




DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2236	REV. C SHEET 1 OF 1
DATE 05.06.07		TITLE LID RIB	SCALE 1:4
A	94.05.30	NEW ISSUE	
B	94.12.16	LID	
C	05.06.07	UPDATE NOTES, CHANGE RADIUS TO 19.0	

RELEASED

05-08-19 *[Signature]*



**D2236**

D2236 LID RIB

- 1) MAKE FROM D3166-3 BASKET HOOP
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES AER PER DART QSI 018 UNLESS OTHERWISE NOTED

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QTY -041	PART NUMBER	DESCRIPTION
X	D3266-041	BASKET ASSEMBLY
2	D2232-1	HINGE PLATE
4	D2236	RIB
2	D2327-1	BUSHING
1	D2506	LABEL PLATE
2	D2581	MOUNTING BRACKET
2	D3266-1	RIB
2	D3266-3	RIB
6	D3266-5	RIB
3	D3266-7	RIB



**NOTES:**

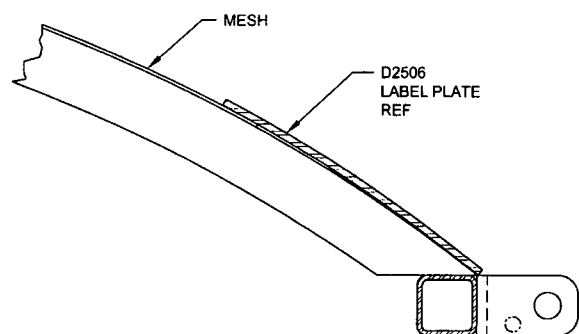
- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

**RELEASED**  
08-29-04/14

B	INCORPORATED A1. DRAWING UPDATED TO CURRENT STANDARDS. SHEET 5 ADDED. RIB MATERIAL WAS 0.060 THICK.	AJS	08.08.15
A	NEW ISSUE	CP	04.02.02
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3266	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET LID ASSEMBLY (350)	NTS
DATE	08.08.15	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

# 463098

8 7 6 5 4 3 2 1

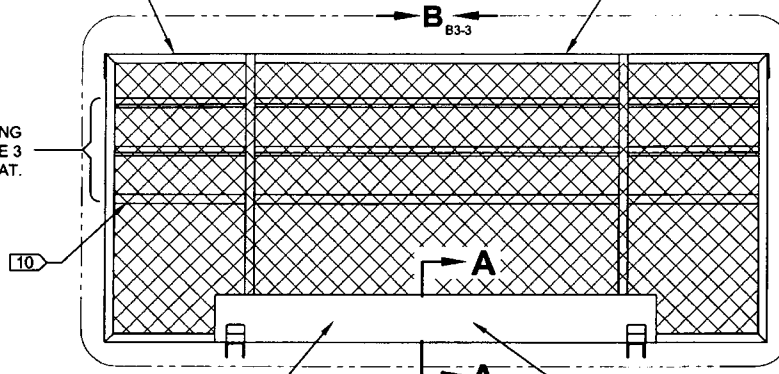


**SECTION A-A**  
(ROTATED 90° CCW)  
SCALE NONE

SKIN OUTSIDE SURFACE OF LID WITH  
SS MESH. TACK WELD  
EACH END STRAND TO FRAME

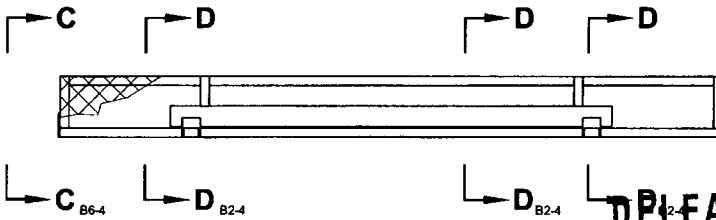
SEE DETAIL B FOR  
FRAME ASSEMBLY

FINISH THIS SECTION ALONG  
ENTIRE LENGTH PER NOTE 3  
AFTER POWDER COAT.



REMOVE 2" X 6" SECTION  
OF MESH FROM BEHIND  
LABEL PLATE

**D3266-041 BASKET LID ASSEMBLY**







**RELEASED**  
18-09-24/18

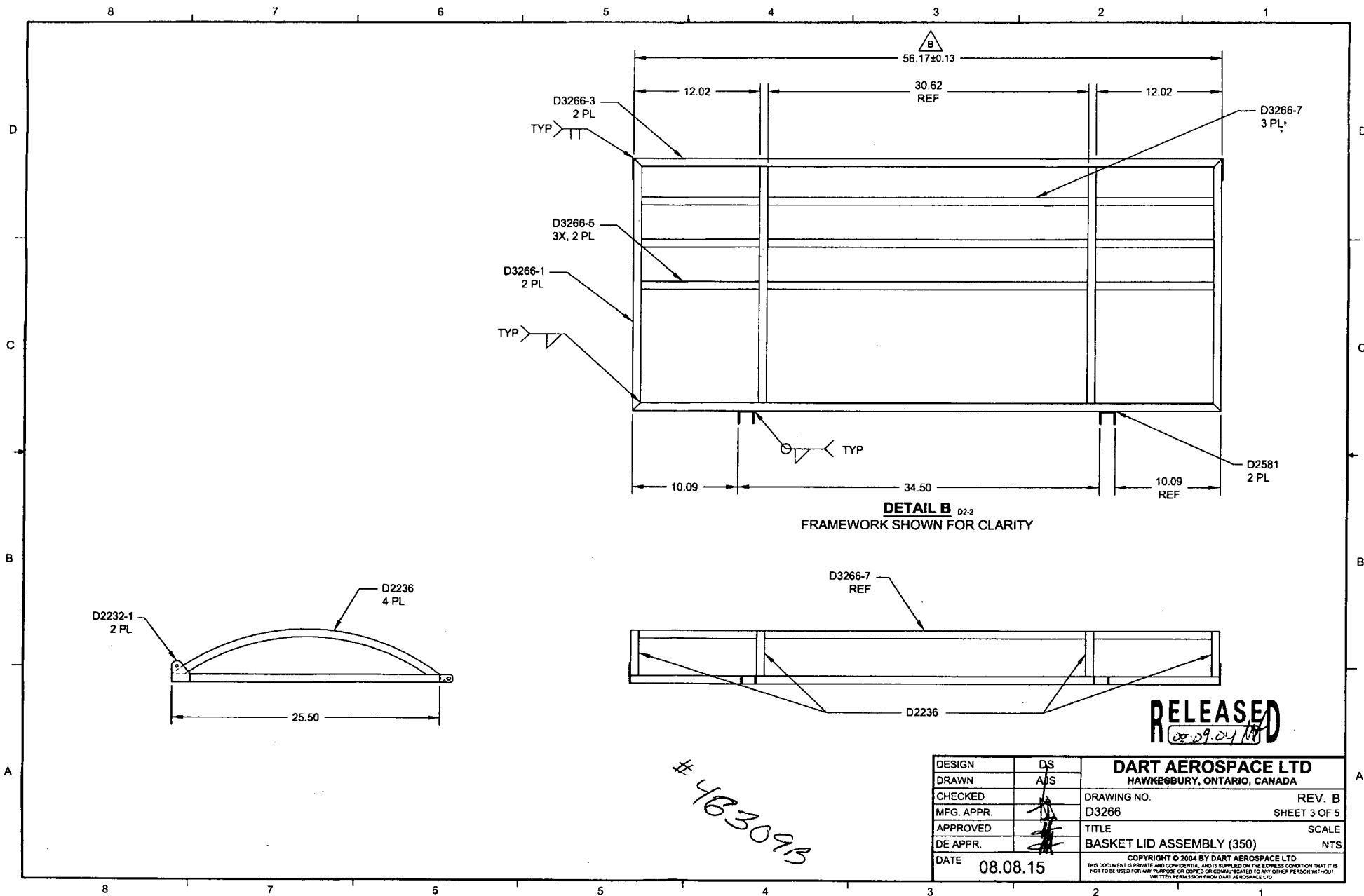
**ASSEMBLY NOTES:**

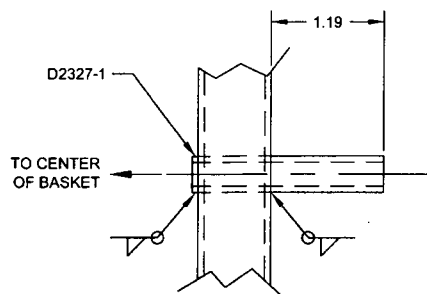
- 1) MATERIAL: SEE SHEET 1
- 2) FINISH: FOR OVERALL FINISH SEE SHEET 1
- 3) FINISH: SPRAY PAINT BLACK INSIDE SURFACE AFTER POWDER COAT  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE  
PER DART QSI 005 4.4 AFTER POWDER COAT
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004
- 10) TACK WELD MESH TO FRAME AT EVERY AVAILABLE LOCATION

#48309B

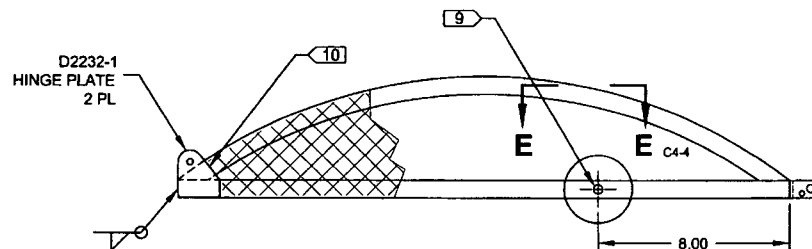
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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3266	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350)	NTS
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8 7 6 5 4 3 2 1

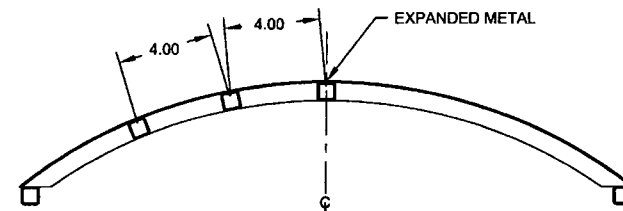




**VIEW E-E** B4-4  
SCALE 4X  
(BOTH ENDS)



**SECTION C-C** A4-2  
(BOTH ENDS)



**SECTION D-D** A1-2  
3 PL A2-2  
A3-2

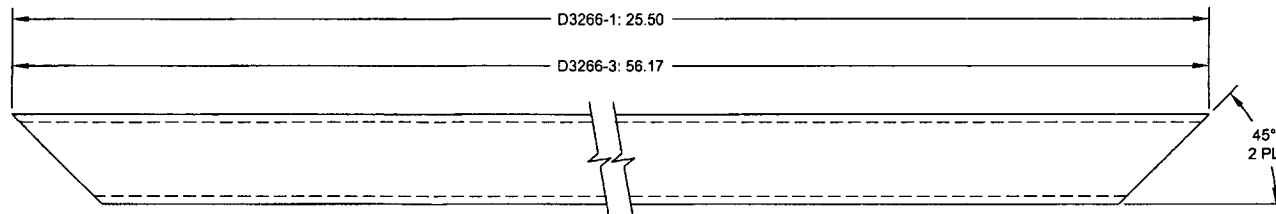
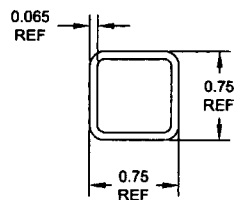
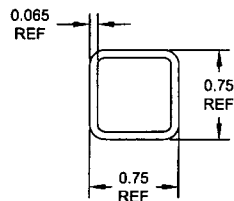
**NOTES:**

- 1) MATERIAL: SEE SHEET 1
- 2) FINISH: SEE SHEET 1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DRILL 3/8 HOLE AND INSTALL D2327-1 USING CLOSEST SPACE IN EXPANDED METAL FOR HOLE LOCATION BOTH ENDS
- 10) TRIM MESH AS REQUIRED TO ALLOW D2232-1 HINGE PLATE TO SIT FLUSH ON FRAME

**RELEASED**  
08.09.15

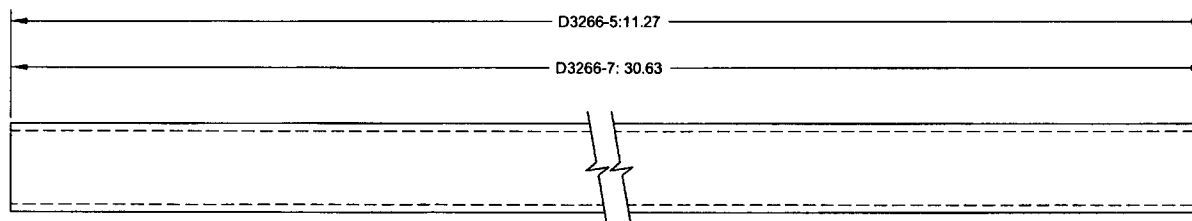
DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RL	DRAWING NO.	REV. B
MFG. APPR.	MP	D3266	SHEET 4 OF 5
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	BASKET LID ASSEMBLY (350)	NTS
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#46307B



**D3266-1 RIB**

**D3266-3 RIB**



**D3266-5 RIB**

**D3266-7 RIB**

**RELEASED**  
08-09-01-17

**RIB NOTES:**

- 1) FRAME MATERIAL: SEE SHEET 1
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

#46309B

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	Pa	DRAWING NO.	REV. B
MFG. APPR.	JS	D3266	SHEET 5 OF 5
APPROVED	AD	TITLE	SCALE
DE APPR.	JS	BASKET LID ASSEMBLY (350)	NTS
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